

**Work Order ID 55596**

January 22, 2010 11:47:46 AM

Page 1

Item ID: D2512

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid 205/350

Start Date: 1/22/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: 1109213 0.00

Large Fab

0.00

Memo

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

0.00

Memo

QC

Quality Control



Large Fab

Large Fab



QC

Q 10/01/28 (1x)

Q 10/01/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

⇒ S1010127



Quality Control

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

⇒ W 10-02-02



Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 7:30AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:00AM

2ND COAT:

START TIME: 8:00AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:30AM

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Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/03  
ME  
10-2-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

January 22, 2010 11:47:45 AM

Page 1

Work Order ID: 55596



Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 1/22/10

Required Date: 2/01/10

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF  
IPP Rev:N 06.04.05 Added level21 EC  
IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2012-117 Manufactured No 100 Each 14.0000 2.0000



Clevis

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
31101	2	
52498	12	

N/A

\*\*\*ONLY APPLICABLE ON D130-701-041\*\*\*

D2232-1 Manufactured No 100 Each 8.0000 2.0000



Basket Hinge

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	6	
51105	6	

✓

2x 10/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 2/01/10

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF  
 IPP Rev:N 06.04.05 Added level21 EC  
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2327-1 Manufactured No 100 Each 43.0000 2.0000



Spacer Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43

52832

23

54658

20

2x 10/01/26

D2506 Manufactured No 100 Each 5.0000 1.0000



Label Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

4

54136

4

1x 10/01/26

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP Rev:N 06.04.05 Added level21 EC  
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 49.0000 2.0000



Mounting Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	46
46086	2
48428	1
51120	2
54862	41

Main Warehouse

WA	3
50872	1
51745	2

✓

29 *SY* 10/01/26

January 22, 2010 11:47:45 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 IPP Rev:N 06.04.05 Added level21 EC  
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No 100 Each 13.1028 1.0000  
 Basket Hoop

SAD 10-01-25

Warehouse Loc Qty Loc Code

Location

Main Warehouse

53494

2.102775

53494

2.102775

Main Warehouse

ST

5

48429

5

Main Warehouse

WA

6.000014474

52058

1.4474E-05

54018

6

M304EX0.75-16F Purchased No 100 sf 1,128.208 18.9474  
 Expanded Metal Flat SS

SAD 10-01-25

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

1128.208506

110134

3.4

111956

0.000017

112147

9.4736E-06

112949

32.58138

113205

0.0093

113497

273.8947

113555

818.3231

18.9474

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP Rev:N 06.04.05 Added level21 EC  
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

429.7553

45.8741



SAD 10-01-25

304 SQ Tube .75x.75x.065W

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

429.7552742

113082

0.00419

113245

129.751084

113683

300

46.8841

Main Warehouse

WA

0.0000047

112398

0.0000047

January 22, 2010 11:47:45 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
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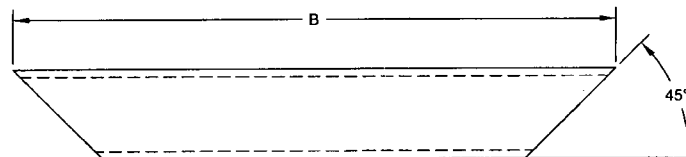
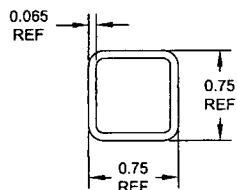
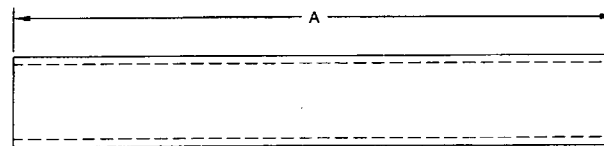
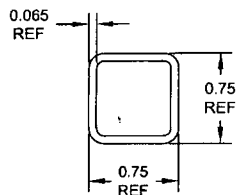
**NOTE:** Date & initial all entries

# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 53594  
B-10-1-21



RELEASED  
08-06-21/17

E	INCORPORATED D1 & D2 MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION, THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

## D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

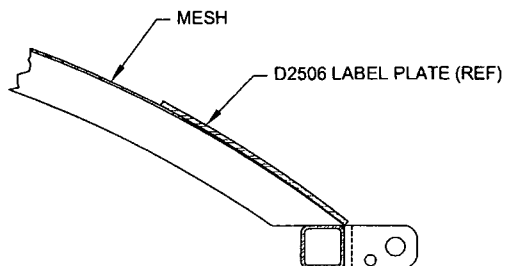
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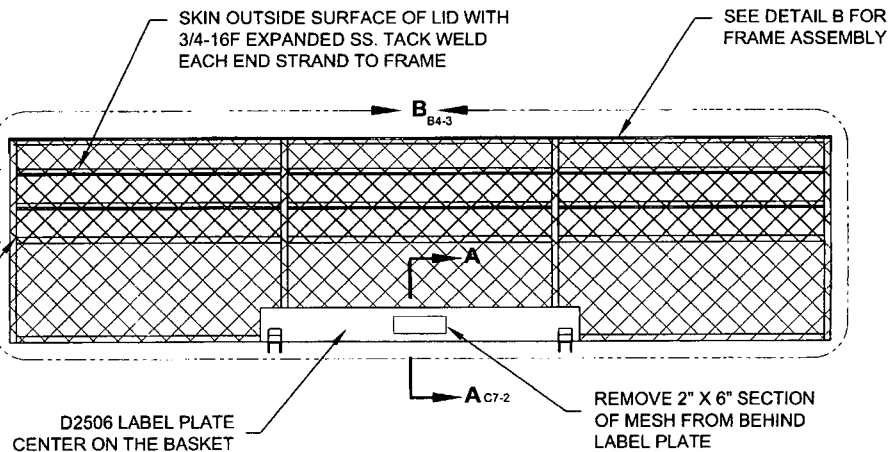
**NOTE:** Date & initial all entries



**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

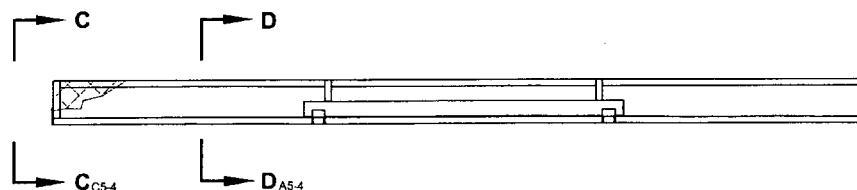
FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



**RELEASED**  
05.05.21/11

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	S	DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

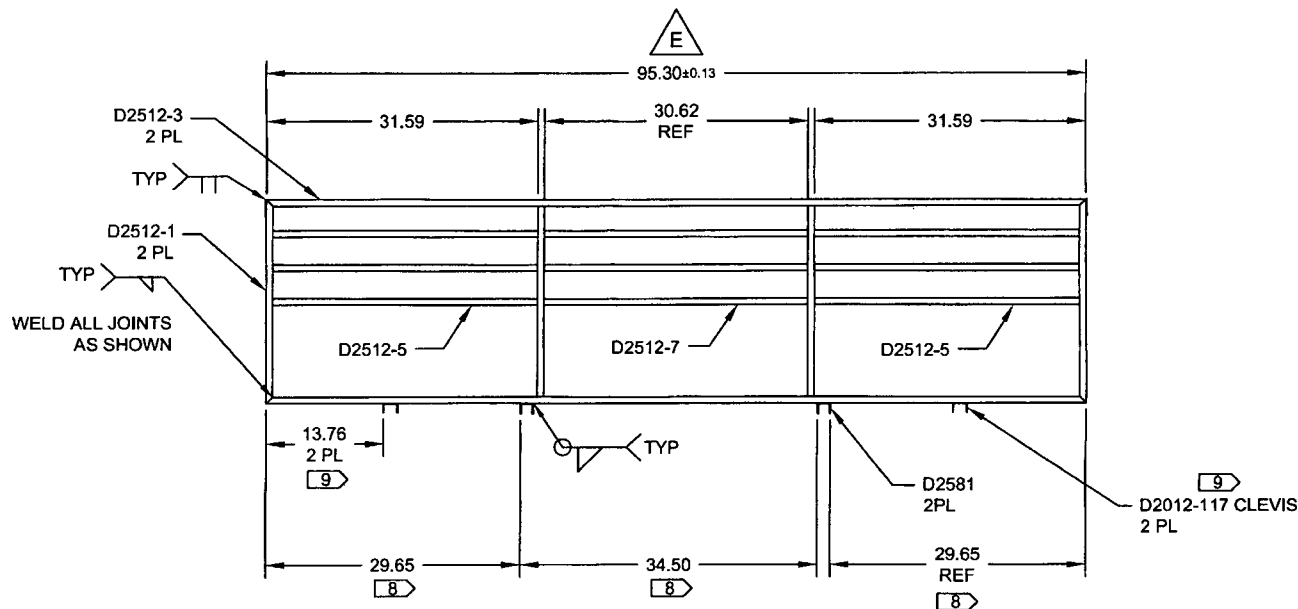
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

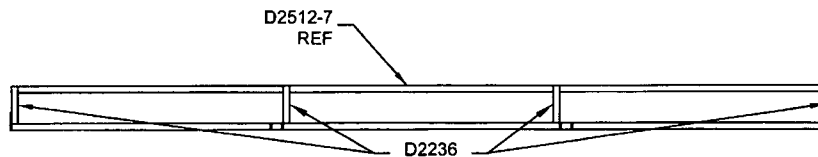
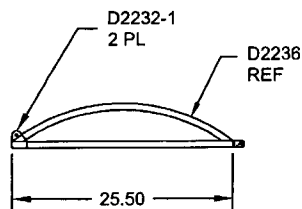
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**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

**RELEASED**  
08.06.17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	AS	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	HA	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

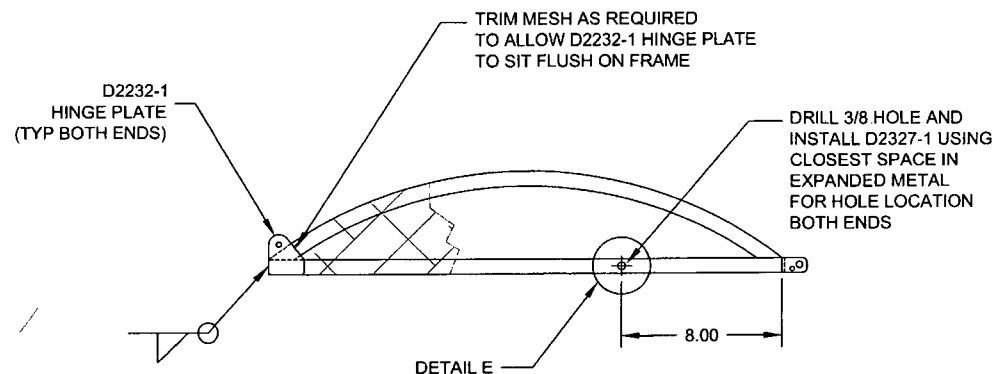
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

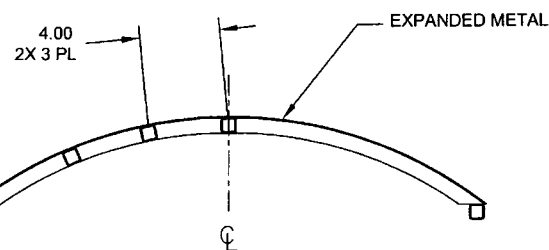
**NOTE:** Date & initial all entries



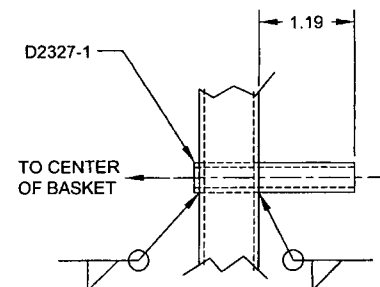
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2







**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

**RELEASED**  
08-06-17

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries